

candles
to
Burn



THREE GENERATIONS OF KNOW HOW

This book of new, advanced, professional CANDLE CRAFTING IDEAS is the result of many, many years of experience in the field of wax formulations and candle making.

Written by Tom Yaley, many candle secrets are exposed and precise step by step instructions for obtaining perfect results are offered by a man who is probably the most informed in the field of professional candle making.

For 36 years the Yaley family, owners of Paragon Wax Refining Company, have been prime suppliers of quality waxes for food, cheese, frozen food and allied industries.

The Yaley brothers, Tom and Fred, bring these many years of professional know-how to the Candle Crafting Division — Yaley Enterprises — assuring the consumer the finest Candle Crafting waxes and materials obtainable and the most complete and professional techniques for candle crafting.

This book brings to you three Generations of Candle Crafting expertise. And while this is a book filled with professional candles and techniques, it has been written in such a way that even beginners may participate and create outstanding candles.

Artis Aleene Eckstein

PLEASE READ CAREFULLY BEFORE STARTING CAUTIONS

CANDLE CRAFTING is exciting, fun and easy to do, BUT there are certain PRECAUTIONS that you should take when working with this medium.

DO NOT EXCEED 260° when melting wax.

There are many candle projects in which the temperature of the wax must exceed 200°. Sand casting is ineffective unless the wax is hot enough to penetrate the sand.

Since you are limited in the temperature you can achieve by heating wax in a double boiler — you will find it necessary to heat your wax on direct heat for professional results.

YOU MUST STAY ALERT and CONCENTRATE ON YOUR PROJECT. Hot wax, if you exceed the temperatures called for, may catch fire. Candle waxes contain oil similar to cooking oils — that are flammable at very high temperatures. HOWEVER with your staying alert and watching the thermometer at all times, there need not be any accidents. It is necessary to use a thermometer when melting wax as you cannot tell how hot it is by looking. Put thermometer into the pot at the start of melting the wax so that it registers accurately. If the thermometer does not reach into the wax, make a holder from 18 gauge wire.

SHOULD THE WAX CATCH FIRE BECAUSE OF OVERHEATING, IMMEDIATELY SMOTHER THE FIRE with a lid or baking soda. DO NOT USE WATER as this just spreads the fire.

Keep small children away from the area of the hot wax. Should any hot wax touch the skin, run cold water over the burn to harden the wax — peel

the wax off and treat as any burn. Be especially careful of wax "splashing" when pouring. Pour slowly.

... Use a seamless pot (pouring container). It must have a spout for safe pouring. You may purchase these pots or perhaps find an old pot in a thrift and welfare shop.

... Place mold in an aluminum pie tin when pouring. Should the mold leak, the wax would be caught in the pan. If leaking occurs immediately pour cold water into the pan. The cold water sets the wax and stops the leaking.

... Watch common, ordinary household paraffin waxes as they have different melting points and, thus, different "flash" points.

... USE A SPECIAL formulation of wax specifically for candle making — Yaley's CANDLE CRAFTING PREMIUM BLOCK WAX. You do not need to add "hardeners", stearic acid or other additives as Premium Wax already includes the special ingredients needed for pouring professional looking candles. Should you use common refinery wax, you must add Stearic acid or Translucent or Opaque crystals to make the wax harder. See directions on the package.

The information in this instruction book is presented in good faith, but no warranty is given, nor results guaranteed, nor is freedom from any patent to be inferred. Since we have no control over physical conditions surrounding the application of information herein contained, we disclaim any liability for untoward results.



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TO FOLIATE A CANDLE



Petal forming candles, also known as angel wings, are made through the selection of the proper wax and wick combination for the diameter of the candle. Use Yaley's Premium Wax block and a medium wire wick for a 3" candle. Light the candle and let it burn until the wall or rim is soft — approximately 2-3 hours. Slightly pinch the sides of the soft wax to start foliation. When the wall of wax is soft enough, the wall buckles outward, splits from its own weight and starts the petal formation. When burned periodically, say 3 hours at a time, interesting ripples form on the petals.

HINTS

CHOOSING YOUR WAXES

Candles are only as good as the wax formulation used. Choosing the best wax for the job will help you to obtain professional candles. Oil content controls burning qualities. Less oil, less smoking, longer burning, truer dye colors and translucent glow to candle. Yaley's Premium candle waxes have been re-refined to contain less than 1% of 1% oil content.

Candles made from most candle waxes will droop or sag in hot weather unless you add stearic acid. This acts as a hardener in the wax which gives the candle a higher resistance to heat. With Yaley's Premium Candle Crafting Wax, you do not have to add stearic acid as hardeners are already added.

Yaley refines other waxes for specific uses such as shaping wax, glass fill wax, taper wax, and batik wax, etc., in addition to formulating a competitive hard candle wax.

CHOICE OF WICKING

Choice of wicking is very important. A wick too large for the diameter of the candle will smoke excessively, will burn too fast and the wax will run over the sides of the candle.

A wick that is too small will "extinguish itself" because it doesn't burn the wax.

There are two types of wicking — wire and bleached. Use wicking as suggested in instructions and on the package.

MOLD CARE

After 5 or 6 pourings in a Metal Mold or if frosted areas appear on your candles, the Molds must be cleaned. Holding finger over wick hole, pour 2 or 3 ounces of Mold Cleaner into mold. Splash around to thoroughly wash all sides, then return Mold Cleaner to can for next use. The clean Mold must have a new application of Mold Release. Holding Mold upside down spray Mold Release up into Mold for only a fraction of a second. Place Mold on table and allow mist to settle on Mold surfaces. Your Mold is now ready for use.

IMPERFECTIONS

If your candle has imperfections, it may be due to several things. You are not pouring at the correct temperature. Your mold is not clean. You did not use the right wax. If all else fails — read the directions in the instruction book. If candle does have any imperfections, you may give the candle a HOT water bath.

If there are fingerprints, etc. on the candle, buff it with a damp paper towel. Place towel under water, wring it out and rub towel back and forth on

candle, in order to give your candle a high gloss, shiny, professional finish when completed, use Yaley's Candle Crafting Hi-Gloss.

DYES

Use concentrated dyes for best results. Yaley's dye blocks are in 8 sections. Shave off the amount desired. You cannot always tell by looking at the melted wax the color your candle will be when it sets up. If you want to make a test, drop a little of the melted wax on a piece of white paper. This will set up quickly and give you an idea of the color.

WAX SPILLAGE

If, any time, you spill wax onto any surface like floor, sink top, table, let harden and then remove with a spatula. Do not try to wipe up while still liquid, you will only make a mess of it. To hasten the hardening, pour cold water over the spill. It will harden immediately. Then lift with the spatula and it will come up clean. It is always advisable to completely cover any work surface with layers of newspapers when working with wax, but sometimes the wax will get onto surfaces where you do not want it. Remove it by the above method. If it splashes onto the stove and the stove is hot, then it can be wiped up immediately with paper towels. It will come off from a warm or hot surface.

BURNING CANDLES

It is advisable, when burning candles, to either place them onto a candle holder or a dish of some kind.

SCENTS

Use concentrated scents. A very little goes a long way. Excess scents tend to mottle a candle or cause blemishes.

ADDITIVES

Opaque Crystals are used as a hardener and to give a base for true coloring. Opaque Crystals make a white candle whiter.

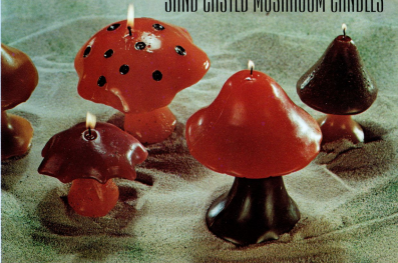
Translucent Crystals make the wax more transparent so that you can see items that are embedded in them. It also acts as a hardener.

Stearic Acid or Stearic Flakes must be added to all inexpensive refinery type candle waxes before pouring a candle.

If displaying candles without bases — be certain to attach a wick tab to bottom on wick. Candle will stop burning when it reaches this metal tab.

NEVER LEAVE THE HOT WAX UNATTENDED.

SAND CASTED MUSHROOM CANDLES



THE FOLLOWING CANDLE CRAFTING MATERIALS BY YALEY ARE NEEDED:

- 1 Block of Hard Wax & Stearic Acid — or — PREMIUM CANDLE CRAFTING WAX BY YALEY — 4 lb. (No additives needed)
- 1 Package Metal Core Wicking — small or medium depending upon size of candles
- 1 Pouring Container (melting pot) or old coffee pot — in which to heat wax (must have pouring spout)
- 1 Candle Thermometer (Candy thermometer alright)
- 1 Package Concentrated CANDLE CRAFTING DYE
- 1 Package Concentrated CANDLE CRAFTING SCENT

PLUS

Sand — from beach or building supply company — approximately 30 lbs.

- 1 dishpan plastic or metal approximately 11"x13"x 5" depth

- 1 bottle with a long, narrow neck for mushroom stem

Hammer and chisel or screwdriver

Light bulbs different sizes

Wax paper

1 old metal tablespoon

Ice pick

Propane torch optional

PROCEDURE:

STEP ONE WORK AREA

Select work area near your stove or hot plate. NEVER LEAVE THE HOT WAX UNATTENDED. Cover the area with newspapers. Assemble your supplies and tools.

STEP TWO PREPARING WAX

To melt the wax, you must first break it up into small enough pieces to fit in the pouring container (melting pot). To do this, place wax block in cardboard box and, using the hammer and chisel, crack the block. Fill the pot with these wax pieces and place the thermometer in the pot. It will take approximately 2 pounds of Premium wax to make several mushrooms.

STEP THREE MELTING THE WAX

Place the pouring container on an electric hot plate, or directly on an electric or gas stove, or place in a pan of water on the stove and allow the wax to melt. Heat the wax to 170°. Watch constantly as it heats faster on direct heat, particularly on a gas stove. **DO NOT LEAVE THE POT UNATTENDED AT ANY TIME**, if the doorbell or phone rings, or baby cries, take the pot from the fire.

STEP FOUR PREPARING THE SAND MOLD

While the wax is melting, prepare the mold. Fill the dishpan with sand within 1" of the top. Wet the sand with water. Use approximately 2 quarts of water. Work the water through the sand thoroughly. The sand should be quite wet but not to where the water seeps out. Make the mushroom heads and stems separately. Form the heads of the mushrooms with a light bulb. The size of the bulb determines the size of the mushroom. Just press the bulb down into the sand, turning the bulb at the same time to flatten and smooth and sand. Fig. 1. Do not have the bulb too close to the sides as you have to have sand all around the mushroom head.

To form the mushroom stems, use the bottle neck. Press the neck of the bottle into the sand, wiggle the bottle until you have a smooth hole with a larger opening at the top. Fig. 1. You may, when shaping sand before pouring, make variations of the mold. Use the head of a refrigerator bulb for a bell shape or take your fingers and "flute" the sand. Fig. 2 - 3.



Fig. 1



Fig. 2



Fig. 3

STEP FIVE ADD DYES AND SCENT

When the wax reaches 170°, add the color to it. When using Yaley concentrated dye chips, a "very little goes a long way". Simply shave off a few shavings of concentrated dye and place into the melted wax. Stir with a dowel until all dye dissolves. When using the dye, 3 or 4 shavings will give you a light color, while 1/4 of a block will give you an intense color. Stir with a dowel until all dye dissolves. If you want to make a test, drop a little of the melted wax on a piece of white paper. This will set up quickly and give you an idea of the color.

Shave 1/4 of a block of Concentrated Candle Crafting Scent and add to the hot wax. Do not use too much scent as it is unnecessary and an excess of oil scent will cause blemishes or mottling on the candle surface.

STEP SIX POURING WAX

Pour the wax into the sand mold. To pour the wax smoothly, hold a metal tablespoon a fraction off the bottom of the head mold. Pour the wax slowly into the spoon. It will run out over the edge of the spoon and will not make a hole in the mushroom head as pouring directly into the sand would. Pour the wax up to the edge of the sand. Pour the stem mold full. Let cool. In one hour, refill the stems as when cooling the wax will have shrunk and formed a well. Heat your wax to 170° again. Refill stem only.

STEP SEVEN SETTING UP

When cold to the touch, pull the mushroom heads and stems from the sand. Brush off as much sand as you can. Rinse them off to remove more sand and wipe them off with a paper towel.

STEP EIGHT SHAPING MUSHROOM

If your mushroom is still not shaped the way you want it, you can contour it or take off additional sand with a propane torch. There are some small easy to handle torches available or you can use a sharp knife and carve the candle into the shape you want. Light the torch and play it over the mushroom with an up and down motion. Wax will run and sand will melt off.

STEP NINE ASSEMBLING MUSHROOM

To adhere the two pieces together, drop a little melted wax, the same color, into the bottom center of the mushroom head. Set the small end of the stem into the melted wax. Hold the stem tight against the head for a few seconds to take hold. Place in cool water for a minute to set firmly.

STEP TEN WICKING

Heat an ice pick over a flame 'til it is quite hot. Push the pick down into the top of the mushroom. Be careful so as not to damage the wax. If the pick is too cool or you push too fast, the wax will crack. Push a piece of wire wicking down into the hole left by the pick. To secure wick drop a little melted wax into the hole around the wick using the tip of a dowel stick to transfer hot wax from pot to candle. You should have about 3 inches of wick sticking out the top of the mushroom. Let cool.

STEP ELEVEN DIP FOR SMOOTH FINISH

As an alternative to using a torch for smoothing the finish, heat a pot of wax to 190° and dip the mushroom. Use the wax the same color as the mushroom and have enough wax in the pot to cover the mushroom when dipped into it. You might need to use a coffee can or other container that has a large opening. Hold the mushroom by the wick and dip it into the pot. Hold it there for a slow count to 10. Remove from the pot and set on a piece of wax paper to cool and harden.

ALUMINUM FOIL CASTED CANDLES



THE FOLLOWING CANDLE CRAFTING MATERIALS BY YALEY ARE NEEDED:

- 1 Block of Hard Wax and Stearic Acid — or — PREMIUM CANDLE CRAFTING WAX BY YALEY — 4 lb. Block (No additives needed)
- 1 Package Metal Core Wicking — medium or large depending upon size of candles
- 1 Pouring Container (melting pot) or old coffee pot — in which to heat wax (must have pouring spout)
- 1 Candle Thermometer (Candy thermometer alright)
- 1 Package Concentrated CANDLE CRAFTING DYE
- 1 Package Concentrated CANDLE CRAFTING SCENT
- 1 Package CANDLE CRAFTING Wick Tabs
- Hammer
- Chisel or Screwdriver
- Plastic or metal pan (to hold aluminum foil mold)
- Aluminum kitchen foil — Heavy Duty
- Thin Wooden Dowel — to hold wicks

PROCEDURE:

Use same wax melting procedure as shown on Page 5 Step 1, 2 and 3. Melt to 190°.

STEP FOUR PREPARING ALUMINUM FOIL MOLD

Tear off a square of aluminum foil approximately 18"x18". This, when shaped, will be your candle mold. Shape the foil into a free form mold. Or, for a design, cut your foil into a circle. Place a jar, like a peanut butter jar, in the center of the circle, and form the foil into petal shapes up around the jar. Fig. 1.

Fig. 1



When you get the shape you want, set the foil mold into a pan where the edges of the mold just touch the sides of the pan. Pour cool water into the pan. Do not get any water into the mold. The mold will float until the wax is poured into it.

STEP FIVE WICKING

Cut a piece of wick about 3 inches longer than the height you plan to make your candle. Fasten a metal wick tab onto one end of the wicking. Wrap the other end of wick around the center of a dowel. Lay the dowel across top of the mold. The wick tab should just miss the bottom of the mold. If too short or long, adjust wick on dowel to give the right length. Be sure the wick is centered in the mold.

STEP SIX POURING THE WAX

Pour the wax into the mold to the level you desire. Set aside to cool. After one or two hours you can place the mold into the refrigerator for an hour or two for quicker release. Remove the foil from the candle when set up.

STEP SEVEN MULTI COLORED CANDLES

These candles may be made in multi-colored layers. If pouring in colored layers, let one layer harden before pouring the next color. You can add chunks to these candles for a different effect.

JELLO MOLD CANDLES



THE FOLLOWING CANDLE CRAFTING MATERIALS BY YALEY ARE NEEDED:

- | | |
|--|--|
| 1 Block of Hard Wax & Stearic Acid — or — PREMIUM CANDLE CRAFTING WAX by Yaley — 4 lb. Block (No additives needed) | 1 Package Concentrated CANDLE CRAFTING DYE |
| 1 Package Metal Core Wicking — large | 1 Package CANDLE CRAFTING Scent |
| 1 Pouring Container (melting pot) or old coffee pot — in which to heat wax — (must have pouring spout) | 1 Package CANDLE CRAFTING Wick Tabs |
| 1 Candle Thermometer (Candy Thermometer alright) | 1 Package Wax Chunks — Your color choice |
| | Plus |
| | Hammer |
| | Chisel or Screwdriver |
| | 1 Metal Jello Mold 7" Diameter — Fluted |
| | 1 Thin wooden dowel stick — for holding wick |

PROCEDURE — FOR CHUNK CANDLE

STEP ONE WORK AREA

Select work area near your stove or hot plate. NEVER LEAVE THE HOT WAX UNATTENDED. Cover the area with newspapers. Assemble your supplies and tools.

STEP TWO PREPARING WAX

To melt the wax, you must first break it up into small enough pieces to fit in the pouring container (melting pot). To do this, place wax block in cardboard box and, using the hammer and chisel, crack the block. Fill the pot with these wax pieces and place the thermometer in the pot. It will take approximately two pounds of Premium wax for the candle.

STEP THREE MELTING THE WAX

Place the pouring container on an electric hot plate, or directly on an electric or gas stove, and allow the wax to melt. Heat the wax to 190°. Watch constantly as it heats faster on direct heat, particularly on a gas stove. DO NOT LEAVE THE POT UNATTENDED AT ANY TIME. If the doorbell or phone rings, or baby cries, take the pot from the fire.

STEP FOUR PREPARING THE MOLD

Wipe the jello mold to remove any dust or dirt. Cut a piece of wicking 3 inches longer than the height of the mold. Fasten a wick tab onto one end of the wicking. Wrap the other end of the wicking around a dowel or pencil. Lay the dowel or pencil across the top of the mold. The wick tab should just miss the bottom of the mold. If it is too long, roll more wicking over the dowel until it is the proper length. Fig. 1.



Fig. 1

STEP FIVE ADDING DYE

When the wax reaches 190°, add the color to it. Simply shave off a few slivers of concentrated dye and place into the melting wax.

If you add chunks to the candle, do not use too strong a dye color because it obscures the chunks. You will get some color from the chunks when the wax is poured over them, so be sure the dye you use will blend well with the color of the chunks.

STEP SIX ADDING SCENT

Shave ½ of a block of Concentrated Candle Crafting Scent and add to hot wax. Do not use too much scent as it is unnecessary and an excess of oil scent will cause blemishes or mottling on the candle surface.

STEP SEVEN CANDLE WITH CHUNKS

To make a candle with chunks, when the wax is melted to 190° and dye and scent have been added, pour about 2 inches of wax into mold. Drop in some chunks to above wax level. Pour more wax up to within 1 inch of the top of the mold. Drop more chunks into the mold until they are higher than the sides of the mold. Pour wax over the chunks to adhere them to the candle. Pour the wax up almost to the top edge of the jello mold. Let set overnight. Will drop out of mold when cold.

PROCEDURE FOR CANDLE WITH SAND AND CHUNKS

Follow Steps One, Two and Three. For preparing mold, take damp sand and put a thin layer around the inside wall of mold and over the bottom of the mold. Add wick as in Step Four. Heat the wax to 190°. Add dye and scent. Pour about 2 inches of wax into mold slowly so as not to disturb the sand. Drop in the chunks. Pour more wax up to 1 inch of top edge of mold. Drop in more chunks into the mold until they are higher than sides of mold. Pour wax over the chunks to adhere them to the candle. Pour the wax up almost to top edge of mold. Let harden.

PROCEDURE FOR COLORED LAYER CANDLE

To make a colored layered candle, when the wax is melted to 190°, separate wax into thirds, by taking 2 cans and putting a third into each can and leaving a third in the pot. Put a different color (dye) into each pot. Pour the first color up to ⅓ height of the mold. Let harden but not cool. If you let the wax become too cool, it will pull away from wall of mold, letting the second pouring run down between the candle and mold wall, ruining the candle. Heat the second color to the same temperature and pour. When hard but not cool, again pour in the third color.

PROCEDURE FOR MAKING WAX CHUNKS

Yaley's Wax Chunks are made of a specially formulated wax that retains its shape and the colors will not bleed when hot wax is poured on them.

However, you can make your own. Anytime that you have any wax left from pouring a candle, do not throw it away — and do not leave it to harden in the pot.

Bring wax to 210°. Add Lustre Translucent Crystals (according to directions on the box) and stir to dissolve. Crystals help "harden" the wax.

Spray a pie tin or cookie sheet with Yaley's Mold Release. Pour Wax into the pie tin to about ½ inch deep. Let set until wax is soft, not hard. Using a sharp knife, cut into squares as you would cut fudge. Let harden. Remove the squares from pan. Put the squares into bags and label for future use.



DECOUPAGED AND WAX PAINTED CANDLES



THE FOLLOWING CANDLE CRAFTING

MATERIALS BY YALEY ARE NEEDED:

- 1 Block of PREMIUM CANDLE CRAFTING Wax by Yaley — 4 lb. Block (No additives needed)
- 1 Block Premium Shaping Wax by Yaley — 1½ lb. Block
- 2 or 3 Packages Concentrated CANDLE CRAFTING DYES Contrasting Colors
- 1 Ready made candle 3" or more in diameter, original color not important. May be old or damaged.
- Electric fry pan
- Printed picture — any subject you desire — such as cards, gift wrap, paper prints, etc.
- 1 Brush — ½" wide — medium stiff — inexpensive
- 1 - 6 cup muffin tin — or 6 tomato sauce cans
- Tacky White Craft Glue

STEP ONE APPLYING THE PICTURE TO THE CANDLE

Choose a picture of flowers, ships, people, or animals, that will fit on your candle. Glue the picture to the candle with tacky. You may use the picture as is or you may cut it out like decoupage.

STEP TWO PREPARING THE WAX

Put about 1" of water in electric fry pan and set the muffin tin into the pan. Candle wax alone will not work for this technique as it will not adhere to

the candle. Make a mixture of ½ Shaping Wax to ½ Premium Wax. Shave one color dye into each cup. Set temperature control to 300°. When all the wax is melted turn temperature control to 250°.

STEP THREE APPLYING FIRST COAT OF WAX ON CANDLE

To put on the first coat of wax, brush it on with the ½ inch wide brush. Brush from the edge of the print outward, slightly overlapping the print so as to hide the edge. Avoid brushing the wax over the picture at this time. Brush back and forth with short quick, sloppy strokes, picking up more wax as you work. The wax will build up as you add more layers. The rough texture or dry brush look is obtained by continual stroking until the wax on the brush is cool. Do not cover candle completely.

STEP FOUR APPLYING SECOND AND THIRD COATS AND FINISH

Using another color wax, brush on a second coat. Apply this coat right over the first coat. Do not cover completely. Let some of the first coat show through. If a rougher texture is wanted, brush back and forth as the wax cools. Repeat with third coat.

To seal the picture to the candle surface, brush on a hot layer of clear or light colored wax. Brush quickly and in one direction only to obtain a smooth finish over picture.

GOLD LEAF CANDLES



THE FOLLOWING CANDLE CRAFTING MATERIALS BY YALEY ARE NEEDED:

- 1 Block of Hard Wax & Stearic Acid — or — PREMIUM CANDLE CRAFTING WAX by Yaley — 4 lb. Block (no additives needed)
- 1 Metal Mold — round, square or hexagon — any size, any height
- 1 Ready made candle for core or center of mold 1" smaller than diameter of Metal Mold and 1" shorter than Mold — should have long wick
- 1 Package CANDLE CRAFTING Mold Sealer
- 1 Pouring Container (melting pot) or old coffee pot — in which to heat wax — must have pouring spout
- 1 Yaley Candle Thermometer (Candy thermometer alright)
- 1 Package Luster Translucent Crystals

- 1 Package CANDLE CRAFTING DYE (color of core candle)

- 1 Package Concentrated CANDLE CRAFTING SCENT

- 1 Package Creative Finishes Gold Leaf
- 1 Piece of string or thread 2' long
- 1 Dowel for stirring
- Aluminum pie tin
- Tablespoon and paring knife

PROCEDURE:

STEP ONE WORK AREA

Select work area near your stove or hot plate. NEVER LEAVE THE HOT WAX UNATTENDED. Cover the area with newspapers.

STEP TWO PREPARING MOLD

Note: if core candle is not flat on top, slightly carve top to make it flat. Fig. 1. This makes candle set better. To prepare the mold, place the core candle upside down in the mold with the wick sticking out the hole in the bottom of the mold. To do this, run a string through the hole in the bottom and out the top of the mold. Tie this string to the core candle wick and pull the wick through the hole. Fig. 2.

Seal the hole with the Mold Sealer.
To be effective, work and knead the sealer before applying to mold. Press sealer around and over wick to seal hole and to hold wick in place. Then press edges of sealer to really adhere to mold. Be sure the candle is centered in the mold.



Fig. 1



Fig. 2

STEP THREE PREPARING THE WAX

To melt the wax block, you must first break it up into small enough pieces to fit in the pouring container (melting pot). To do this, place wax block in cardboard box and, using a hammer and a chisel, crack the block. Fill the pot with these wax pieces and place the thermometer in the pot.

STEP FOUR MELTING THE WAX

Place the pouring container on an electric hot plate, or directly on an electric or gas stove and allow the wax to melt. Heat the wax to 210°. Watch constantly as it heats faster on direct heat, particularly on a gas stove. DO NOT LEAVE THE POT UNATTENDED AT ANY TIME. If the doorbell or phone rings or baby cries, take pot from fire.

STEP FIVE ADD CRYSTALS AND COLOR DYE

Use Translucent Crystals so that you make the wax transparent and the gold leaf will show. When the temperature reaches 210°, put a tablespoon of Yaley's Translucent Crystals into the pot and stir to dissolve. Add dye. For best results, use wax block

dye. Shave the dye into the pot. Yaley's dye is separated by lines into 8 sections. 1/8 of the dye block makes a light color. Use more if you want a darker shade but suggest for gold leaf that you use a light color. Stir with a wooden dowel to dissolve.

STEP SIX ADDING SCENT

Shave 1/8 of a block of Concentrated Candle Crafting Scent and add to hot wax. Do not use too much scent as it is unnecessary and an excess of oil scent will cause blemishes or mottling on the candle surfaces.

STEP SEVEN POURING WAX

To pour, let the wax cool to 180°. Place mold into aluminum pie tin for safety. Should mold leak, cold water, poured at base would set the hot wax. Pour the wax into the mold over the core candle until you cover the core candle. Save a cup of wax for refill. Gently, using a wooden dowel stick, press pieces of gold leaf down into the mold up against the mold wall. Tear gold leaf in 1/4 to 1/2 sheet size. Use approximately 6 sheets in a 2 1/2" diameter 10" high candle. The leaf will stay where you put it if you poke gently. Do not agitate the wax. When you have the amount of leaf you want in the mold, set it aside to cool.

STEP EIGHT FILLING THE WELL

As the wax sets up, it forms a well on the top. After about 1 1/2 hours, poke several holes into the wax as near the core candle as possible. If you go out against the mold wall you will leave marks on the candle surface. The holes are to relieve the pressure built up by the cooling wax. Heat wax to 190°. Repour the well. After this well has set, it may sink again. Repour again if it does.

STEP NINE SETTING UP TIME

You may let the candle set out overnight before removing it from the mold, or if you are impatient, you may place the mold in the refrigerator for an hour or more to hasten the set. When the mold is cold to the touch, the candle should be ready to be removed.

To take the candle out of the mold, turn the mold upside down over a table with your hand over the open end of the mold. The candle should release easily when turned upside down and tapped on your hand.

NEVER LEAVE THE HOT WAX UNATTENDED.

WHIMSICAL CHARACTER CANDLES



THE FOLLOWING CANDLE CRAFTING MATERIALS BY YALEY ARE NEEDED:

- 1 Block of Hard Wax & Stearic Acid — or PREMIUM CANDLE CRAFTING WAX by Yaley — 4 lb. Block no additives needed
- 1 Package Metal Core Wicking — medium
- 1 Pouring Container (melting pot) or old coffee pot — in which to heat wax (must have pouring spout)
- 1 Candle Thermometer (Candy Thermometer all-right)
- 1 Package Concentrated CANDLE CRAFTING DYE
- 1 Package CANDLE CRAFTING Wick Tabs
- Hammer
- Chisel or Screwdriver
- 1 Dishpan approximately 11" x 13" x 5"

Sand — from beach or building supply company approximately 30 lbs

- 1 Brush ½" wide medium stiff
- 2 Small round beads — for eyes
- 2 Dressmaker pins — to fasten on eyes
- 3 pieces 18 gauge wire for legs
- 1 roll Florist tape
- 1 Wooden dowel — for stirring wax

Propane torch. This is a necessity for this type of sculpturing. If you are a beginner, there are several types of torches on the market. Some are very small, easy to use, miniature torches that may be purchased at hardware, drug, or home improvement stores. Cost approximately \$5.00.

STEP ONE WORK AREA

Select work area near your stove or hot plate. NEVER LEAVE THE HOT WAX UNATTENDED. Cover the area with newspapers. Assemble your supplies and tools.

STEP TWO

Fill dishpan full of sand to within 1" of top. Wet the sand with approximately 2 quarts of water. Work the sand until all of the sand is equally moist. The PELICANS (flying and standing birds) in the picture were made right side up. The SAND PIPER (large bird) was made upside down. The legs are put on after the bird is removed from the sand.

Don't try to dig detail into the sand. You can get the detail with the torch. Just try to obtain the general idea.

For either one of the birds, use your hand and dig a free form of the body in the sand. For the PELICAN, make a round hole in the sand with an oval bottom, and to the depth you want the bird's body, approximately 3" to 4". Fig. 1 shows top view of the body. Pat and moisten the sand with water to keep the sides from crumbling. For the SAND PIPER dig a shape similar to the one in the photo.

To make the wings on the PELICAN, with your hands remove the sand on either side of the body to a depth of 1 inch. Make a tail the same way. Fig. 2.



Fig. 1

Fig. 2

To make the head and beak, dig a tunnel in the sand 1½ inches wide at the body to a point at other end. Beak can be 3" to 4" long and 1½ inches deep. Fig. 3.



Fig. 3

STEP THREE PREPARING WAX

To melt the wax block, you must first break it up into small pieces. To do this, place wax block into cardboard box and, using a hammer and chisel, crack the block. Fill the pot with these wax pieces and place the thermometer into the pot. It will take approximately two pounds of premium wax for each bird.

STEP FOUR MELTING THE WAX

Place the pouring container onto an electric hot plate, or directly onto an electric or gas stove, and allow the wax to melt. Heat wax to 180° maximum. The lower the temperature when pouring, the less the wax will penetrate the sand and the less sand on the bird.

STEP FIVE WICK

If you are making the PELICAN (right side up), cut a wick about 3 inches longer than you need. Fasten a metal wick tab to one end of the wick. Wrap the other end of the wick around a dowel stick. Lower the wick into the sand mold. The tab

should just miss the bottom of the mold. The wick should be straight when the dowel stick is laid across the top of the mold. The large SAND PIPER (standing bird) will have to have a wick put in after the bird is taken out of the sand. Just heat an ice pick and make a hole down into the top of the bird and insert the wick into this hole.

STEP SIX ADDING THE DYE

When the wax reaches 180° add the color to it. Simply shave off a few slivers of concentrated dye and place into melting wax. Stir into the wax to dissolve. Before pouring hold a metal tablespoon down into the mold just missing the mold bottom. Gently pour the wax into the spoon. This prevents you from making deep holes in the mold. Fill the mold with the wax up to the top of the mold. Let set to cool.

STEP SEVEN REMOVE SAND FROM BIRD

Remove the bird from the dishpan and brush off the sand. Most of it should come off if the sand was wet when the wax was poured and you poured at a low temperature of 165° to 180°.

STEP EIGHT SHAPING THE PELICAN

To give the bird a better shape, use a propane torch and melt lines, shapes and grooves where you want them. Remember do not have the heat too long in any one place as you can melt the wax completely away and ruin the bird. Use the torch as though you were using a knife to sculpt with.

STEP NINE PAINTING WAX FOR TEXTURED SURFACE

When the bird is shaped, take 2 or 3 small cans, place a small amount of wax in each. Use either an electric fry pan or a pan large enough to set the cans into. Add about an inch of water in the pan or fry pan. Set the cans of wax into them.

Melt the wax, if melting on the stove, remove from stove when melted. Add a color dye to each can. Using the brush, stroke the wax over the body of the bird. You can brush one way or back and forth. Brush one color over another, letting the first color come through here and there. If you want the surface rough, brush back and forth with short strokes and continue until wax is cold and set up. The colder the wax, the deeper the texture, the rougher the surface. The higher the temperature, the smoother the surface. Black wax has been brushed over the beaks of the small birds.

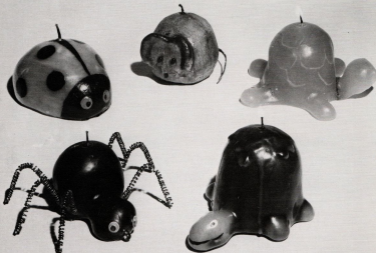
STEP TEN ADDING EYES, BEAKS, ETC.

Using pins, stick the two beads into the head for eyes. The large bird has a piece of coat hanger wire for a beak. This has been put in by holding one end with pliers, heating the other end and pushing it into the wax.

The legs are formed of heavy wire. For the standing PELICAN, cut 6 pieces of wire 5" long. Secure the 3 pieces of wire together in the center 1/3rd only with florist tape. Bend 1½" forward for feet. Fig. 4. Insert other ends of wire into bird body. You may have to heat them before inserting. Legs for the SAND PIPER are made with the same wire, cut in 10" pieces. All legs are brushed with green or black wax for rough texture.



Fig. 4



CANDLE CRITTERS

The Candle Critters are made using almost the same procedures and the same materials as for the Whimsical Characters on Pages 13 and 14.

STEP ONE MAKE SAND MOLD

Fill dishpan full of sand to within 1" of the top. Wet the sand with approximately 2 quarts of water. Work the sand until all of the sand is equally moist.

All of the figures are made upside down. To make the turtle, scoop a hole in the sand approximately 2" in diameter and 2½ inches deep for the body. Using the thumb, press a shallow hole for each leg. Make a deeper hole for the head. Slant the head down as in Fig. 1 or leave it flat.

All bodies are made using this general procedure. Note ears on mouse and head shape on spider.

Fig. 1



STEP TWO MELTING WAX

Break up the wax and place the wax chunks into the melting pot. Place the pot on an electric hot plate and heat to 180°.

STEP THREE POURING THE WAX

Refer to Step 6 on Page 14.

STEP FOUR WICKING

The critters will all have to have the wick put in after they are removed from the sand. Heat an ice pick and make a hole down into the center top and insert the wick into this hole.

STEP FIVE REMOVING SAND AND SHAPING

Refer to Step 7 and 8, on Page 14.

STEP SIX FINISHING CRITTERS

The mouse was a charcoal color wax and the texture was achieved by brushing melted wax (lavender) over the surface.

The lady bug was made of red wax and was painted with black acrylic paints.

The spider was dipped in hot wax. His legs were made of 22 gauge wire wrapped around knitting needles. End of curled wire was heated and forced into body.

The turtle was poured of green wax. Decorating Drip Wax was applied to the back of the turtle. Eyes and mouth were painted on with acrylic paints.

SCULPTURED FLOWERS FROM WAX



THE FOLLOWING CANDLE CRAFTING MATERIALS BY YALEY ARE NEEDED FOR SAND CAST CANDLE WITH TINY SCULPTURED FLOWERS

- 1 Block of Premium CANDLE CRAFTING Wax by Yaley (no additives needed)
- 1 Block Premium Shaping Wax by Yaley — 1½ lb. Block
- 1 Pouring Container (melting pot) or old coffee pot — in which to heat wax (must have pouring spout)
- 1 Candle Thermometer (Candy thermometer all-right)
- 1 Package Concentrated CANDLE CRAFTING DYE
- 1 Spray can Candle Mold Release
- 1 concentrated CANDLE CRAFTING Scent
- 1 Ready made Sand Cast Candle
- Hammer
- Chisel or Screwdriver
- Aluminum cookie sheet
- Electric food warmer or heating pad
- Cloth towel
- Xacto knife
- Aluminum foil

ADDITIONAL MATERIALS NEEDED FOR LARGE ROSES

- 1 Package Metal Core Wicking — small
- Ice pick
- 2" or smaller resin glass molds for large sculptured flowers only

PROCEDURE:

STEP ONE WORK AREA

Select work area near your stove or hot plate. Cover the area with newspapers. Assemble your supplies and tools.

STEP TWO PREPARING WAX

Use ½ lb. of Yaley's Premium Wax and ½ lb. Shaping Wax. To melt the wax blocks, you must first break them up into small enough pieces to fit into the pouring container (melting pot). To do this, place wax blocks into cardboard box and, using the hammer and a chisel, crack the blocks. Fill the pot with these wax pieces and place the thermometer into the pot.

STEP THREE MELTING THE WAX

Place the pouring container onto an electric hot plate or directly onto an electric or gas stove, and allow the wax to melt. Heat wax to 170°. Watch continually as it heats faster on direct heat particularly on a gas stove. **DO NOT LEAVE THE POT UNATTENDED AT ANY TIME.**

You will need to make two batches — one for the green leaves and one for the color desired for the flowers. Or you can divide your wax, coloring each separately.

STEP FOUR ADDING COLOR DYE AND SCENT

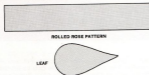
When the wax reaches 170° add the color to it. Simply shave off a few slivers of concentrated dye and place into melting wax. Stir with a dowel until all dye dissolves. Add scent.

STEP FIVE PREPARING MOLD AND POURING WAX

Spray cookie sheet lightly with the mold release. Pour a 1/8 inch thick layer of green wax onto the cookie sheet. Immediately when the wax becomes set but is still hot, remove from the cookie sheet. Loosen one end with a knife and pull the sheet up gently. If you have trouble getting it up, set it on the heat for a few seconds and heat will loosen it. Lay the wax sheet onto aluminum foil. Place the aluminum foil onto a towel and then onto a food warmer or a heating pad at lowest temperature to maintain warmth. The wax must be kept in a workable state. If too cold, it will break and too hot it will not hold its shape. With a little practice, you will learn the right temperature for the wax you are using. Repeat procedure with colored wax for flowers.

STEP SIX TINY ROLLED ROSES AND LEAVES

To make the roses and leaves around the edge of the sand casted candle, place the patterns on the colored wax and cut out. Use an Xacto knife or scissors and cut out as many leaves and flowers as needed. Shape the leaves while the wax is soft. If a wax leaf becomes hard to shape, place it back onto the warmer to soften.



For the small rolled roses, start to roll petal from left to right as shown in Fig. 1. As you roll, pinch the top edge of the petals to flatten it and to shape and flute it. Fig. 2. Adhere the roses and leaves to the candle surface with hot melted wax or a wood burning tool.



PROCEDURE FOR LARGE ROSE

The center may be rolled using a larger pattern and the same procedure for the tiny roses but place

a wick in the center as you roll. For better burning qualities, the center bud may be a wax ball — made in resin glass molds.

Be sure glass molds are clean and free of dust inside. Set them upright in a pulp egg carton or a pan of sand. Fig. 3. Heat colored wax to 170° and pour into mold. Let set 'til hard.

To remove the balls of wax from the molds, place the molds in a sack or wrap in a paper towel. Tap gently with a hammer to break the glass. If you hit too hard you will put marks on the wax ball. Remove the broken glass from the ball. Work gently so as not to cut yourself. Take all wax balls from their molds.

To put wicking into the balls, take the ice pick and heat. Push the pick down into top of ball. Be careful. The pick has to be quite hot or the ball will crack. Cut a length of wicking about 1 inch longer than ball. Stick the end into melted wax. Then push it down into the ball. Fill the hole around the wick with a little melted wax.

Cut a small petal from the wax sheet. See pattern. Pinch around the top edge of the petal to make it thin. Shape the petal by bending the top edges on either side of the center back, Fig. 4. Using the thumb, cup in where darkened area is on Fig. 4



Fig. 3



Fig. 4

petal. Do 4 more small petals. Fasten these, evenly spacing them, around the ball. Put petals on, one at a time fastening them with hot wax or a wood burning tool. The top of the petals should stick 1/4 inch above the top of ball. The opening across the top of the ball should be 1 1/2 inches in diameter. Make and put on a second row of petals using the large petal pattern. Make 5 petals for this row. This row should drop down from 1/2 to 3/4 inch from edge of previous row of petals. Make a third row using 7 large petals. To finish off the candle cut a 1 1/4 inch diameter circle of wax. Fasten to bottom of candle with melted wax or a wood burning tool.



DECORATING DRIP WAX ON CANDLES



THE FOLLOWING CANDLE CRAFTING MATERIALS BY YALEY ARE NEEDED:

Made up candles

Package Drip Wax #1 Purple Candle—Blue, Green

#2 Sand Cast—Orange, Pink, Yellow

#3 Sand Cast—Chartreuse, Green, Blue, Turquoise

Propane torch or small sauce cans

YALEY'S DECORATING DRIP WAX IS A SPECIAL BLEND THAT GIVES THE WAX A GREAT ADHESIVE QUALITY — FLEXIBILITY — A NON-CRACKING FINISH — A SPECIAL PLASTIC-LIKE INGREDIENT THAT MAKES IT UNIQUE.

STEP ONE MELTING IN SAUCE CAN METHOD

Cut up one color drip stick into each can. Melt each can of wax over the hot plate or stove. Watch and continually stir until the complete stick is

melted. CAUTION: Never leave the hot wax unattended. The cans will be quite hot, so lift them using a pair of pliers. Drip one color first directly from the can. Pour the wax slowly around the edge. Let the wax run in uneven drips down the sides of the candle. When you have put on one color, drip the next color over the first one. Do not cover up the first color but run the second color between the drips of the first one. If you want, you can use a third color.

STEP TWO TORCH METHOD OF MELTING

Light a propane torch and holding the drip stick with a pair of pliers, melt the stick, slowly, letting it run down the candle sides. Do not drip the wax around the wick of the candle as it will prevent the candle from burning.

If you are putting it onto a sand casted candle, turn the candle upside down and work around the bottom edge.

STALAGMITE DRIP WAX CANDLE



THE FOLLOWING CANDLE CRAFTING MATERIALS BY YALEY ARE NEEDED:

6 Packages Decorating Drip Wax

2 orange

2 yellow

2 pink (hot)

Plus

1 jar or glass with straight sides — at least 4" dia.

1 tall thin bottle — to hold inverted jar

Propane torch or sauce cans to melt in

Votive candle

Newspaper

Candle Holder

DECORATING DRIP WAX ADDS AN EXCITING DECORATIVE "DIPPING" EFFECT TO CANDLES OR WINE BOTTLES. PREPARED WITH SPECIAL CHEMICALS, THIS DECORATING DRIP WAX IS MORE PLASTIC LIKE TO HOLD SECURELY TO THE CANDLE. UNLIKE DRIPPING REGULAR CANDLE WAX OR OTHER CRIBBLE TYPE WAX, YALEY'S DECORATING DRIP WAX DOES NOT BREAK LOOSE OR CHIP OFF. WILL NOT CRACK WHEN IT SETS UP AS DO ORDINARY WAXES.



PROCEDURE:

STEP ONE WORK AREA

Cover the work area with plenty of newspapers. If torch method is used, be sure to work on a fire-proof surface — aluminum foil, cement, etc.

STEP TWO

To start your Stalagmite Candle, turn the jar upside down over the neck of the tall bottle. This is to let the drips extend beyond the edge of the jar without touching the table. Fig. 1.



Fig. 1

STEP THREE DRIP PROPANE TORCH METHOD

This is the most professional method to use. Since many professional candles are made or sculpted with a torch, this is a good project for you to learn to work with the torch.

There are some very easy to use — amateur type of torches called Mini-torches that are available at drug, hardware and home improvement centers and sell for approximately \$5.00. Fig. 2.



Fig. 2

The more professional hand torch would be good to use if you plan to make professional candles for resale. So many of the fantastic candles you see displayed in gift stores have been sculpted with a torch. Fig. 3.



Fig. 3

Light the torch. Holding one color of drip wax with a pair of pliers, play the torch over the end of the drip wax. Do not melt the wax too fast as it will quickly run off onto the newspaper. Run the wax down the sides of the glass starting near the edge. Do not put wax over the complete bottom of the glass. Leave an opening so when it is turned right side up and set over a candle holder, a votive candle can be placed in the center. Therefore, when you want to light the votive candle, just lift off the stalagmite candle. Work completely around the glass with one color. You do not have to have the color solid around the glass.

STEP FOUR DRIP SECOND COLOR

Melt the second color and let drip over the first one. Let the drips run as far as they will go. They will run down over the previous drips and each time they will grow a little longer. Mix the colors.

STEP FIVE FINISHING

Build the candle with as many layers as you desire. Do not try to cover the jar solidly, let some light come through.

When the wax is entirely cold, it will pull away from the glass sides. Lift out the glass and you will have a beautiful stalagmite candle.

MELTING DRIP WAX IN CAN "METHOD"

Should you prefer to drip wax by a simple method, you may melt the Decorating Drip Wax in small cans.

Cut up one color drip stick and place into can. (Small tomato sauce cans work very well.) Repeat this procedure with each color. Melt wax directly over hot plate or stove. Watch and continually stir until the complete drip stick is melted. Wax heats faster on direct heat, particularly on a gas stove. Do not leave the pot unattended at any time. The cans will be quite hot, so lift them using a pair of pliers. Drip one color first directly from the can. Pour the wax slowly around the edge. Let the wax run in uneven drips down the sides of the candles. When you have put on one color, drip the next color over the first one. Do not cover up the first color but run the second color between the drips of the first one. If you want, you can use a third color.

Note: If you work slowly and drip wax starts to set up — be sure to reheat.

HAND CARVED CANDLES



THE FOLLOWING CANDLE CRAFTING MATERIALS BY YALEY ARE NEEDED:

1 Ready made candle 3" or more in Diameter

Xacto knife

Wood burning tool

Acrylic paint — your color choice or metallic gold paint

1 Paint brush — small-round #3 or #4

1 Spray Can Candle Hi-Gloss by Yaley

Pin

Scotch tape

STEP ONE TRANSFER DESIGN TO CANDLE

Transfer the design to the candle. To do this, tape the pattern to the candle. Using a pin, gently prick through the paper, following the lines of the design. Make holes about $\frac{1}{8}$ inch apart. Fig. 1. Do not push the pin into the candle too far. This will leave too deep a hole that you will be unable to carve out.



Fig. 1

STEP TWO CARVE

When the design is transferred onto the candle, remove the pattern. Using the Xacto knife, carve from outer edge to the center dotted line. Always carve from a solid line to a dotted line. Dotted lines represent the deep cut. When carving a leaf, start with a shallow cut at one end to a deeper cut in the center and to a shallow cut at the other end. You are making a "V" cut. All of your cuts will have to be into the candle as you are working on a flat surface. How you make your cuts determines the height and depth and contours of your finished work.

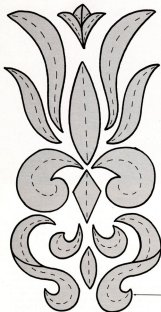
STEP THREE SMOOTH FINISH

Clean up your carvings with the wood burning tool. This will smooth out any rough spots left by the cutting. Do not hold the burning tool in one spot too long as you do not want the wax to melt and run over the candle. Just touch here and there to smooth.

STEP FOUR PAINT CARVINGS

To paint the design, use acrylic paints, undiluted. You can paint the design all one color or use various shades of one color. You can paint the entire design using a metallic gold or silver paint.

When the paint is entirely dry, spray two coats of Yaley's Hi-Gloss onto the candle to give it a professional look. Be sure and let the first coat thoroughly dry before spraying on the second coat. Two light coats are better than one heavy coat to avoid runs.





WAYS TO DECORATE 3D CANDLES

Here are some suggestions for decorating candles. There is no limit to the effects you can get by painting, brushing, rubbing different media onto the candle surface.

PAINTING WITH WAX

Give a different look to your 3D Candles by painting two to three colors of liquid wax over the surface of your candle. The grape candle in the picture was painted with red, green, and lavender. To paint, melt a mixture of $\frac{1}{2}$ Yaley's Premium Wax and $\frac{1}{2}$ Shaping Wax. Place in 3 separate cans and color each wax with Yaley's Concentrated Dye.

Using a stiff paint brush, stroke on one color, then brush a second color, hit and miss, over the first color. To get a rough or textured look, brush back and forth quickly with short strokes. Continue until brush is very dry.

For a smooth look, brush quickly with long strokes in one direction only. Do not let the brush become cold. Dip often into the hot wax.

GOLD ANTIQUED

To give the candle a different finish, coat the

raised surface with gold. Use a paste metallic gold finish, "Treasure gold" by Patricia Nimocks. Pick up the gold on your finger and wipe across the candle surface, highlighting the raised areas.

ANTIQUING

To antique a candle, use an antiquing material that will be compatible to the candle. Creative Finishes antiquing liquid "Mission Umber" works fine. Brush the liquid over the candle, covering all areas. Let set a minute or two, then wipe off the raised surfaces with a soft cloth. Do not try to remove too much. Leave the antiquing in the creases. When dry, to highlight the antiquing, if desired, brush a little gold over the surface of the candle.

PAINTING WITH ACRYLICS

Use tube paints as they are thicker. Using a fine round brush, paint in the details such as a yellow flower, orange center, green leaves. Paint the background a contrasting color. This technique is like painting a picture except you already have the picture, you are just bringing it to life with the colors.

TULIP CANDLES



THE FOLLOWING CANDLE CRAFTING MATERIALS BY YALEY ARE NEEDED:

- 1 Block of PREMIUM CANDLE CRAFTING WAX by Yaley no additives needed
- 1 Block Yaley's Shaping Wax
- 1 Package Metal Core Wicking — size to fit dia. of candle
- 1 Pouring container (melting pot) or old coffee pot in which to heat wax (must have pouring spout)
- 1 Candle Thermometer (Candy Thermometer alright)
- 3 Packages Concentrated CANDLE CRAFTING DYE — contrasting colors
- 1 Package CANDLE CRAFTING Wick Tabs
- 1 Package Translucent Crystals
- 1 Spray Can Mold Release

Plus

- 1 Thin dowel stick
- 1 Aluminum pie tin or pizza pan 9" dia.
- 1 Glass jar — straight sides 3½" dia. and approximately 6" high
- 1 Bucket or pan 8" dia.
- Wax paper
- Hammer and chisel
- Paper towels

The tulip candle is made in 3 parts. The outside shell is formed first and allowed to harden. Then another color of wax is poured into the shell. This is allowed to set up and shrink. When cold and hard, a third color is poured on top to form a star shape.

PROCEDURE:

STEP ONE WORK AREA

Select work area near your stove or hot plate. NEVER LEAVE THE HOT WAX UNATTENDED. Cover the area with newspapers. Assemble your supplies and tools.

STEP TWO PREPARING WAX FOR SHELL

Use equal amounts of Premium Wax and Shaping Wax. For the average candle, one pound of each wax should be enough to make the outside shell depending on the size of the pan. Break up the wax with a hammer and chisel and place wax in pot. Place a thermometer into the pot.

STEP THREE MELTING THE WAX

Place the pouring container on an electric hot plate, or directly on an electric or gas stove, and allow the wax to melt. Heat the wax to 190°. Watch constantly as it heats faster on direct heat, particularly on a gas stove.

STEP FOUR ADDING COLOR DYE

When the wax temperature reaches 190° add the color you want for the outside shell. When using Yaley concentrated dye block a very little goes a long way. Simply shave off a few slivers of concentrated dye and place into melting wax. When using red, 3 or 4 shavings will give you an intense red. You cannot always tell by looking at the melted wax the color you will get when the candle sets up. If you want to make a test, drop a little of the melted wax on a piece of white paper. This will set up quickly and give you an idea of the color. Be sure to stir with a dowel until all dye dissolves.

STEP FIVE PREPARE MOLD

Set the glass jar upside down onto a piece of wax paper. Have a bucket of water available for chilling and setting wax.

STEP SIX POURING WAX IN PAN

Be sure the pan is clean and free of dust. Wipe pan and spray lightly with Mold Release. Pour the wax into the pie or pizza pan to a 1/4" thickness. Let the wax set up until the wax is firm not hard. It will be quite warm and pliable. Handle gently to keep from tearing or cracking the edges. Loosen edges of the wax in the pan using a knife. Gently pry one edge loose and pull up. If it is hard to pull up, it has set up too much. Place pan on burner for a "couple of seconds" to loosen wax.

STEP SEVEN SHAPING SHELL

Turn jar upside down and place the round disc of wax over the jar bottom. Fig. 1. Center the wax on the jar. Now form the petals. Work quickly while the wax is warm and pliable. See Fig. 2. Make from



Fig. 1



Fig. 2

5 to 7 petals or whatever you like. When the wax shell is shaped to your liking, turn the shell right side up and dip the shell into cold water to help harden it. This way you do not lose the shape, as the wax tends to flatten out when it is still warm. Remove the jar before the wax is too hard. Continue to shape and form flower. To help shell to set, pour water inside flower. Remove shell from the water when hard and wipe the water from the inside with a paper towel. Let set.

STEP EIGHT MELTING WAX FOR SECOND POUR

Melt a pound of Premium Wax in the melting pot. Be sure you put in the thermometer. Let it reach 170°. Add the second color dye. Remove from heat. The cooler the better.

Set the wax shell back in the pan of cool water. Do not let any water get into the shell. Pour the melted wax into the shell up to within 1/2 inch of the edge. If the shell tends to float in the water, set something heavy enough on shell top to hold it down. Be careful so as not to break the shell.

STEP NINE WICK

Immediately, while wax is still liquid, fasten one end of a piece of wick to a metal wick tab. Drop the wick tab down into the center of liquid wax in the shell until it rests on the shell bottom. Wrap the end of the wicking around a pencil or wooden dowel and lay the dowel across the shell top. Let wax harden.

STEP TEN VEINING

When the wax in the shell is set up but still soft, take a pencil or wooden dowel and press lines from the center out to within 1/2 inch of each petal tip. Fig. 3. Let the wax shell remain in the water until it is set and cold. The center around the wick will sink in.



Fig. 3

STEP ELEVEN CENTER COLOR

Melt a small amount of Premium wax. Add the third color. Heat to 190°. Pour the wax gently onto the top of the candle until the wax runs out onto the lines you pressed into the candle top and forms a star shape. Do not pour too much wax. Set aside to cool.

MOTTLING AND MARBLEIZING



If you want the finish of a candle to have a marbled or mottled look, you can achieve this result by using Yaley's Snow Flake Oil. Snow Flakes are accumulations of free oil. Adding Snow Flake Oil to the existing oils in the wax produces this effect. This gives the surface of the candle the look of hundreds of tiny snow flakes.

To do this, heat your wax to the temperature called for by the type of mold — Metal Molds 190°,

or plastic molds 180° or lower. For best results, be sure to use Yaley's Premium Wax and candle molds with smooth surfaces. No crystals should be used when adding Snow Flake Oil. Add the dye to the candle wax AND add mottling oil according to the directions on the bottle — 5 tablespoons to 2 lbs. of wax. This formulation was made for Premium Wax. For other waxes you will have to make tests to come up with the proper amount of oil.

CANDLES WITH THE HAND CARVED LOOK 3D FLUORESCENT



You can quickly cast beautiful candles with intricate designs and the Hand Carved look by pouring wax into plastic 3D Molds. There is a large selection of patterns available at Hobby and Craft stores—see next page for procedure.

Some of the most beautiful candles in the world are hand carved. On Page 21 we show you the technique of this process. However, those with limited time and talent can achieve the same look by using Professional 3D Plastic Molds.

Yaley Enterprises has commissioned top arts and crafts designer, Katie O., to hand carve several designs. For the first time the mold has been engineered so that the detail is on the inside. Special high temperature plastic is molded so that candles may be poured at higher temperatures resulting in better detail and finish and molds have longer lasting qualities. Below is the procedure for pouring Yaley's 3D Molds. Note: If other plastic molds are used, check for suggested pouring temperatures.

THE FOLLOWING CANDLE CRAFTING

MATERIALS BY YALEY ARE NEEDED:

- 1 Block of Hard Wax and Stearic Acid — or — Premium CANDLE CRAFTING WAX by Yaley — 4 lb. (no additives needed)
- 1 — 3D Plastic Candle Mold by Yaley
- 1 Package Metal Core Wicking — medium
- 1 Package CANDLE CRAFTING Mold Sealer
- 1 Pouring Container (melting pot) or old coffee pot
- 1 Candle Thermometer (Candy thermometer alright)
- 1 Package Yaley's Fluorescent Dye

STEP ONE ASSEMBLE MOLD

Assemble molds according to directions in the box. Assemble side panels using long black clamps supplied, being sure that the pattern is consistent on all sides.

STEP TWO WICKING

Yaley 3D Molds have a special wick holder that centers the wick. It also features a neoprene gasket to prevent leakage. Follow instructions in the mold box. Take your wicking, place the slit in the gasket onto the wicking. Tie a knot around a piece of toothpick at the end of the wicking. Slide the gasket up against the knot. (The toothpick is used to make the knot easier to untie after your candle is finished.) Thread the wicking through the hole in the bottom of the mold. Pull the wick until the gasket (retainer) rests against the mold. Use special wick holder (comes with mold) to center wick. Note: one side of wick holder has "V" slot for securing wick. Pull wick snug and slip into "V" at center of wick holder.

STEP THREE SEAL

NOTE: When pushing mold sealer into place BE SURE TO SUPPORT THE BASE IN YOUR HANDS. DO NOT SET MOLD ON TABLE AND PUSH AS EXCESS PRESSURE MIGHT CRACK MOLD. Using balance of mold sealer, cover gasket, wick knot and toothpick.

Slide the clamps down as far as they will go to assure good seal at bottom and recheck base clamp for security.

STEP FOUR PREPARING WAX

To melt the wax block, break it up into small enough pieces to fit into the pouring container (melting pot). Fill the pot with these wax pieces and place the thermometer into the pot. It will take approximately two pounds of Premium Wax for the 3-D Candle.



STEP FIVE MELTING WAX — ADDING DYES

Fluorescent dyes will add brilliant color to candle wax. Melt your candle wax, cool wax to 170°, OR LESS, before adding the fluorescent dye. Add approximately 1/4 of the block of fluorescent dye to each 2 pounds of candle wax. Stir until dye is dissolved and pour immediately. *Fluorescent dyes need to be stirred or agitated so that they will not settle or separate in the candle.*

STEP SIX POURING WAX

These molds are made from a special high temperature plastic that can withstand higher temperatures than the usual plastic molds. For the best reproduction of the design detail from the inside of the mold, we usually suggest pouring at 210°F, however, with fluorescent dye, do not exceed 170°F. Place mold in pie tin when pouring. Should the mold leak, quickly pour water into pie tin. This will stop leaking.

STEP SEVEN RECAP

As the wax sets up, it forms a well on the top. Take a dowel stick and poke into the candle on either side of the wick to relieve built-up pressure. Reheat a cup of excess wax and pour into this well. NOTE: do not pour the wax beyond the previous pour as the hot wax may run down between the candle and the mold. Wait another hour and repour if necessary. Let set overnight.

STEP EIGHT SETTING UP TIME

Remove candle from mold, carefully remove the mold sealer from the bottom of the mold (save mold sealer as it may be used again). Slip off neoprene wick gasket. Slide out short piece of toothpick and untie "loose" knot. Remove black clamps holding mold together and sides will fall away from candle.

STEP NINE

A sharp knife may be used to trim the "flash" or mold lines. Additional detail may be carved into design if desired.

WATER SCULPTURE CANDLE



INTRODUCTION

This is a candle that takes lots of practice and experimentation. The original idea was devised and is sold commercially by Lenny Williams of Lovellite Candles in Martinez, California.

Katie O. has created a technique so that the home crafter can make a similar looking water sculpture.

The wax used professionally is a special and secret formulation that may be done in one pouring and has extreme hardness. For the home crafter, the combination of Yaley's Premium Wax, Shaping Wax and Decorating Drip Wax will create a similar sculpture that will be slightly more fragile.

THE FOLLOWING CANDLE CRAFTING MATERIALS BY YALEY ARE NEEDED:

- 1 Block Premium CANDLE CRAFTING Wax by Yaley — 4 lb. Block (No additives needed)
- 1 Block Yaley's Shaping Wax 1½ lb.
- 1 Package Concentrated CANDLE CRAFTING Dye
- 2 Packages Decorating Drip Wax
- 1 Package Opaque Crystals
- 1 Pouring Container (melting pot) or old coffee pot — in which to heat wax (must have pouring spout)
- 1 Candle Thermometer (Candy thermometer alright)

Plus

- 1 Ready made taper candle 12" to 15" high (color to match candle) that will be used as core candle
- Hammer and chisel
- Large plastic trash container
- 1 Large plastic trash liner bag
- 1 Small aluminum pie tin or plastic oleo tub (should be 4" dia.)

PROCEDURE:

STEP ONE WORK AREAS

Select work area near your stove or hot plate to melt wax. NEVER LEAVE THE HOT WAX UNATTENDED. Cover the area with newspapers. Assemble your supplies and tools. Note: you will need a second work area outside for actual pouring, see Step 5.

STEP TWO PREPARING WAX FOR CORE CANDLE BASE

For the core candle base, use ½ lb. Premium Wax. To melt the wax block, you must first break it up into small enough pieces to fit in the pouring container (melting pot). To do this, place wax block in cardboard box and, using a hammer and a chisel, crack the block. Fill the pot with these wax pieces and place the thermometer in the pot.

STEP THREE MELTING THE WAX FOR CORE CANDLE BASE

Place the pouring container on an electric hot plate, or directly on an electric or gas stove, and allow the wax to melt. Heat the wax to 170°. Watch constantly as it heats faster on direct heat, particularly on a gas stove.

STEP FOUR TO POUR BASE OF CORE CANDLE

The wax sculpture is formed around a core candle. To hold the candle up, it is necessary to pour a base. Fig. 1. When wax temperature reaches 170° add dye color. Pour this wax into the pie tin or oleo tub. Set the core candle in the center. Let harden. This will take a few hours. Be sure to keep the candle straight. If necessary, prop up the candle to hold in place until set. To hasten cooling, when the wax has hardened, place in cool water. Remove the mold from the base. Your candle should resemble Fig. 1. Set aside.

Fig. 1



STEP FIVE PREPARING CONTAINER FOR BATH

Place the plastic liner bag in the trash container. If container should be weak in some spot and develop a crack, the water cannot escape if you use the plastic bags. I would suggest you make this candle in your garage or back yard. Place the trash container on the floor. Fill the container with cold tap water up to within 6 inches of top edge. It is easier to sit on a chair when pouring this candle as you have better control of the wax. Place a small table next to the can so that you have a place to set the hot pouring container when necessary.

STEP SIX WAX FORMULATION FOR SCULPTURE

Weigh out 2 lbs. of Premium Wax and 1 lb. Shaping Wax. Break up the waxes using the hammer and chisel. Put the wax chunks together into the melting pot. Place the thermometer into the pot. Put the pot onto a hot plate or stove using low heat. DO NOT LEAVE THE WAX UNATTENDED.

If you have to leave the room for any reason, take the pot of wax off the stove.

STEP SEVEN WAX MELTING

Melt the waxes to 210°. Add 1 package Opaque Crystals and 2 sticks of Decorating Drip Wax. Stir to dissolve. Remove the pot of wax from the stove. Add 1/4 of the color dye. Stir to dissolve. Let the wax cool to 160°.

STEP EIGHT CANDLE DECORATIVE BASE

NOTE: Read the full paragraph before starting. Hold the core candle in the water until the base is half submerged. Fig. 2. Pour the wax over the base close around the core candle, see the arrow in Fig. 3. Pour the wax easy and slow. Let the wax flow down over the base of the candle and out over the water. Pour wax on base NOT on water. Keep turning the core candle until the wax puddle becomes a complete circle on the water. The circle will be approximately 10" in diameter. You have to work slowly and gently so as to keep control of the wax. Hold the candle and keep the wax level for a minute or two until the underneath part of circle has hardened. If it gets away from you, break off the parts until you have a circle. Repour to repair circle if necessary. The top will still be liquid wax. Fig. 4. Use a cup to gently scoop water over entire base or circle of wax to harden it.



Fig. 2



Fig. 3

STEP NINE CANDLE SCULPTURED WALLS

Pour the sides in approximately 4 to 6 sections. The picture above shows two of the six sections poured. Start pouring the wax from the pouring pen



Fig. 4



Fig. 5

onto the outside edge of the base, approximately 6" long. Fig. 5. Pour back and forth. This liquid wax will slowly rise as you push the core candle down into the water.

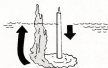
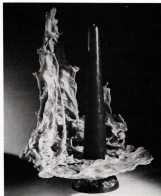


Fig. 6

The trick to pouring is to make an oblong puddle of wax then slowly sink the puddle and it has a tendency to draw in as you sink it. Add a smaller amount of wax — it will "puddle" again and again slowly submerge candle.

When you want the "spires" immerse candle quickly for 1" — it will come in and spread out quickly. This is the technique you will use to finish the top.

Do not pour in too much wax as the wax will rise too far and the container may not be deep enough to take it.

STEP TEN

If you see the wax getting out of hand, that is, spreading out over the water where you don't want it, immediately set hot wax pouring container on the table and use your hand to bring it back into line. Work gently, remembering you are working with liquid wax. When you have one section completed place upside down in water to harden. Repeat the procedure of building sections. As you add sections, parts will adhere to one another.

When the liquid wax is hard and the wall is completed, let the candle lay upside down in the water for an hour or so to become hard. Then remove and drain off the water and set aside on newspapers to dry.



DRIFTWOOD WITH CANDLE LIGHTS

THE FOLLOWING CANDLE CRAFTING MATERIALS BY YALEY ARE NEEDED:

- 1 Block of Hard Wax and Stearic Acid — or — Premium CANDLE CRAFTING Wax by Yaley (no additives needed)
- 1 Package Metal Core Wicking — small
- 1 Pouring Container (melting pot) or old coffee pot
- 1 Candle Thermometer (Candy thermometer all-right)
- 3 Packages Concentrated CANDLE CRAFTING DYE
 - 1 Concentrated CANDLE CRAFTING SCENT
- 1 Large natural wood knot
- Hammer, chisel or screwdriver
- 6 round glass resin molds 2" dia.
- 16 gauge wire
- Large cookie sheet (having four raised sides)
- Soup ladle
- Ice pick
- 2 — 1 lb. coffee cans

Use the Steps 1, 2, and 3 from Page 9.

STEP FOUR PREPARING GLASS MOLDS

Be sure the molds are clean and free of dust inside. Set the molds upright in a pan of sand or a pulp egg carton.

STEP FIVE POURING WAX

When wax reaches 190°, remove the pot from the stove. Pour $\frac{1}{3}$ of the wax into 1 can, and $\frac{1}{3}$

into the 2nd can. Add dye to each batch. Stir to dissolve. Let the wax cool to 170°. Pour 2 yellow balls, 2 orange and 2 brown. Let cool. The wax will pull away from the sides of the glass when they are ready to come out.

STEP SIX REMOVING BALLS FROM MOLDS

Place the molds in a sack or wrap in a paper towel. Tap gently with a hammer to break the glass. Remove the broken glass from the ball. Work gently so as not to cut yourself.

STEP SEVEN WICK

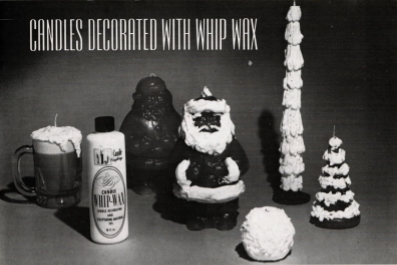
Heat the ice pick and push it down into the top of the ball to make a hole. Cut a 2" length of wicking, stick the end into melted wax, then push it down into the ball. Fill the hole around the wick with a little melted wax.

STEP EIGHT ADHERING BALLS TO WOOD

Cut the wire into 2 inch lengths. Drill holes in the wood knot the thickness of the wire. Glue the wire down into the holes. Push the balls down onto the wire.

Set the wood knot onto a cookie sheet. Heat some clear wax to 210°. Ladle the wax over the balls and the wood. Covering the wood with the hot wax makes it a deep, rich, color and will adhere the balls to the wood.

CANDLES DECORATED WITH WHIP WAX



THE FOLLOWING CANDLE CRAFTING MATERIALS ARE NEEDED:

- 1 Bottle Candle Whip Wax or
- 1 Block PREMIUM CANDLE CRAFTING WAX by Yaley — 4 lb. Block (No additives needed)
- 1 Candle to be decorated
- 1 Cake Decorating tube or plastic bag
- Spatula
- Egg Beater & Bowl

PROCEDURE FOR USING YALEY'S CANDLE WHIP WAX

Pour 1 cup whip wax into a bowl. Whip with an egg beater until stiff. You can apply the whipped wax to the candle with (1) a spatula or (2) a cake decorating tube or (3) a plastic bag.

To cover any candle, use a procedure like frosting a cake. Dab the whip wax onto the candle with a spatula. You do not have to work fast as the wax stays pliable for some time. It will take from 2 to 3 days for the whip wax to become dry and hard.

If you want a decorative design on a candle, use a cake decorating tube. These come with a variety of tips that can be used with whip wax or you can use a plastic bag in place of the cake decorating tube. Put the whipped wax into the plastic bag. Fold down the top of the bag. Cut a tiny hole in one bottom corner of the bag. Squeeze and the wax will come out the hole.

You can color the wax with liquid food coloring. Just add a few drops for shade of color desired then whip.

Immediately after using, rinse all utensils in cool water and dry. Whip wax will come off when still soft. Do not pour whip wax down the drain.

The whip wax on the taper candle was put on with a cake decorating tube. An up and down loop pattern was used. If you do not have the tubes, use plastic bag.

The beer mug has gold colored, glass fill wax poured into it, a wick added, and allowed to set up. The whip wax was put on the top with a spatula.

PROCEDURE FOR USING PREMIUM WAX

Commercial whip wax is best because it is slower setting; however, Premium hard wax can be used as whip wax. No hardeners are necessary. Add a color dye to the hot wax if wanted. Pour the hot wax into a bowl and let cool until a scum forms on the top. Beat with a regular egg beater until the desired consistency has been reached. It should be quite dry and fluffy when ready to use. Keep the bowl on a food warmer or in another bowl of hot water. This keeps the wax from setting up too fast. Clean utensils while still warm by wiping. Do not put wax down drain.

GLASS FILLED WAX CANDLES



THE FOLLOWING CANDLE CRAFTING MATERIALS BY YALEY ARE NEEDED:

- 1 Block Premium Glass Fill Wax by Yaley — 4 lb. Block (No additives needed)
- 1 Pouring Container (melting pot) or old coffee pot
- 1 Candle Thermometer (Candy thermometer alright)
- 1 Package Concentrated CANDLE CRAFTING DYE
- 1 Package Concentrated CANDLE CRAFTING SCENT
- 1 Package Metal Core Wicking — small, medium or large
- 1 Package CANDLE CRAFTING Wick Tabs
- Hammer — Chisel or Screwdriver
- 1 Glass container — any size or type — for mold

STEP ONE WAX

Break up the wax with the hammer and chisel. Put the chunks into the melting pot. Place the thermometer into the pot and place onto the hot plate or stove and heat wax to 165°. DO NOT LEAVE THE WAX UNATTENDED.

STEP TWO TREATING GLASS

If you pour wax that is too hot into a cold glass, the glass might break. Preheat the glass under hot water and wipe thoroughly to remove the water. If any water is left inside the glass it will ruin your candle.

STEP THREE WICKING

Cut off a short piece of wicking, about 3 inches longer than height of area to be poured. Fasten a metal wick tab to one end of the wicking. Roll the other end around a pencil. Place wick into glass. The metal tab should just clear the glass bottom and the pencil should rest on the edge of the glass with the wick straight.

STEP FOUR POURING THE WAX

When the wax reaches 165° shave the dye into it. Pour the wax into the glass up to within 1/2 inch of the top edge of the container. Set aside to cool. Yaley's Glass Fill Wax is formulated so when it burns, the wax dissolves away from the glass leaving it clear. When the candle is burned down to the bottom of the container, simply add another wick and refill again with wax.

PROCEDURE FOR REFILLING CANDLES OF FIGURES AND ANIMALS

No one wants to burn an animal, even a wax one. If you mold figures or animals, use only a small wick. Burn until a hole develops. Refill hole with Yaley's Glass Fill Wax and replace wick.

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